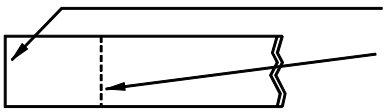
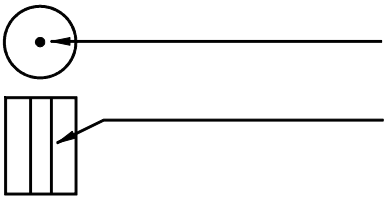
HOW TO FABRICATE RAW BRASS BOUCHER STYLE BANJO NUTS

1



Sand the end of a 12" length of 3/8" brass rod to form a square the end. Mark 1/2" in from end and trim to this length. Sand the cut end lightly to remove the majority of saw cut marks. Re-square the end of the 3/8" rod and repeat these steps for number of pieces needed.

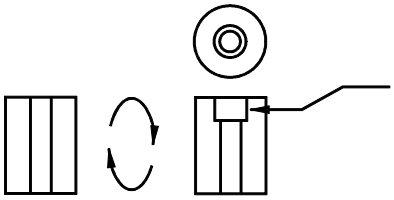
2



Use a fine point Sharpie to visually place a small dot in the center of the originally squared end.

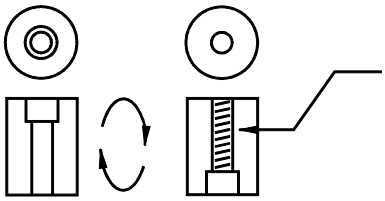
Place the marked square end up in a drill press vise and drill through the nut blank with a #29 drill bit.

3



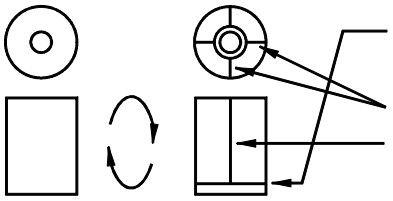
Flip the nut blank end for end and counterdrill the end 11/64" by 1/8" deep.

4



Flip the nut blank end for end again and tap the hole completely trough with a #8 by 26 tpi taper tap.

5

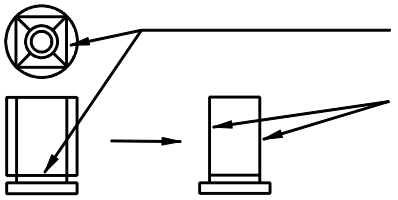


Flip blank end for end again and draw a line 1/8" up from bottom. (Counterbored end now faces up...)

Draw a pair of centered crossed lines across the top.

Extend these line down the sides to meet the previously drawn line 1/8" above the bottom edge.

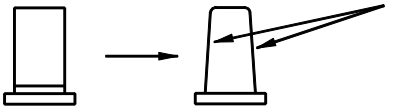
6



Slot down with a fine tooth hack saw to touch line ends on all four sides of previously drawn horizontal line.

Sand down all four sides with 6" 150 grit disk until the excess material is removed to meet the line edges. The top 3/8" of the nut will now form a square extension approximately 1/4" square.

7



All four sides of the nut are sanded to a slight taper toward the top top until they fit a wrench made to the desired internal shape. File surfaces to refine the final shape, round edges, and polish the nut using buffing compound and a cloth buffing wheel.

NOTE: These hand shaped nuts are best made by following the guide steps to produce an example nut to use as a referance for forming the remaining number needed. A wrench should be made next to fit this example nut. The wrench's internal tapered shape can then be used as a gauge when shaping the tapered sides of the remaining nuts.